

TECHNICAL BULLETIN

Our ref. no. ZAMP/9208GA-UK

Subject : MAIN SWINGING PIVOT SHAFT

Dear Sirs,

Some cracks have been occurred and noticed on the welding of both side of the a.m. shaft . (see enclosed to localize the area)

A carefull inspection is recommended to the Galleon ride owners, in order to verify the condition of the weldings, this inspection has to be performed every two operational seasons, at least.

Any kind of crack, on the welding material, doesn't affect the performances and the safety of the ride.

The following are inspection procedures:

1. Verify, with a first visual control, the superficial conditions of the weldings. If some crack is in process, it can be noticed on the enamel coating surface.
2. Perform a non-destructive test by a magnetic crack detector or by penetrant liquid inspection, in the second case the enamel coating must be removed, in order to have the cracked area completely cleaned.
3. If crack has observed, remove the shaft and proceed to disassemble it. Consult our assembly drawing no. 9.207.020.001A, for your reference.
4. Grind the cracked area in order to completely remove the crack. The correct removal of the crack, will avoid the beginning of rust process.
5. Verify again, by magnetic crack test or penetrant liquid inspection, if the crack was completely removed.
6. Pre-heat the area at a temperature of 200°C.
7. Make a new welding following the instruction contained on our drawing no. 9.229.020.003A.
8. Cover the rewelded area with insulating material, in order to get a slow cooling of the repaired area
9. Grind a little the new welding, in order to remove some possible roughness.
10. Repeat again the non-destructive test in order to verify the quality of the job performed.
11. Zamperla company will appreciate any kind of comment and report of the a.m.

